

Work Order ID 144785-2

SPLIT-1

144785

Page 1

April 22, 2016 4:27:22 PM

Item ID: D2893-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support

Start Date: 5/3/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/17/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MUS

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date: APR 25 2016

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2893

C

100

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per Folio FA081
2-Deburr

0.61

10.40

DAS

14

9-89

16/05/05

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

DAS

14

9-89

16/05/05

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.40

DAS

45

9-89

16-05-05

Work Order ID 144785

April 22, 2016 4:27:22 PM

144785

Page 2

Item ID: D2893-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support
 Start Date: 5/3/2016 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 5/17/2016 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS 41 9-89
130						1			16-5-5
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes	Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.	132391							
140	QC3- Inspect Part Finish	0.00							DAS 38 9-89
140						1			MAY 06 2016
QC	Memo	0.20							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.20							DAS 6 9-89
Packaging	LOCATION : LG050								

MAY 06 2016

Work Order ID 144785

April 22, 2016 4:27:22 PM

144785

Page 3

Item ID: D2893-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Support

Start Date: 5/3/2016 Start Qty: 20.00

20

Cust Item ID:

Required Date: 5/17/2016 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run

Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	2.00							
Quality Control									

MAY 06 2016

60160506

Picklist Print

April 22, 2016 4:27:22 PM

Page 1

Work Order ID: 144785

144785

Parent Item: D2893-1

D2893-1

Parent Item Name: Support

Start Date: 5/3/2016

Required Date: 5/17/2016

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C02.11.26Reformat; Added P/OKJ
 IPP D 06.04.19 removed alodine EC
 IPP Rev:E Added priming as per Rev B 07-04-30 JLM
 IPP F 08.03.19 Re-format EC verified by: DD
 IPP Rev:G 08-05-15 add QC14 DD verified by:EC
 11.08.04 as per dwg rev.C DD verf:EC
 IPP Rev:H

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	12.0000	0.5	10.52632			

DSK078

D2893-1 Turning Detail

Location

Loc Qty

Loc Code

MAT060

12

143446

12

10

mk 16/05/05

DART AEROSPACE LTD		Work Order:	144785
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893		Rev: C	Page 1 of 1

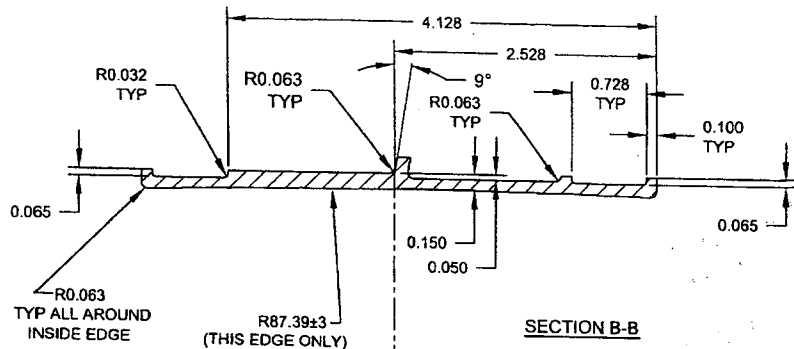
FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.986				
AB	0.440	0.460		.440				
AC	0.125	0.160		.150				
AD	0.040	0.060		.050				
AE	0.188	0.193		.191				
AF	0.125	0.160		.140				
AG	0.140	0.160		.145				
AH	1.360	1.400		1.366				
AI	0.040	0.060		.056				
AJ	1.190	1.230		1.214				
AK	0.010	0.020		.015				
AL	0.053	0.073		.063				
AM	0.240	0.260		.250				
AN	2.518	2.538		2.528				
AO	84.39	90.39		87.39				
AP	0.261	0.266		.261				
AQ	0.053	0.073		.063				
AR								
AS								
AT								
Accept/Reject								

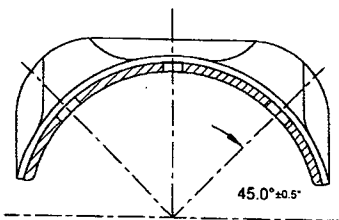
Measured by:	DAS 14	Date:	16/05/05
Audited by:	45 9-89	Date:	16/05/05
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

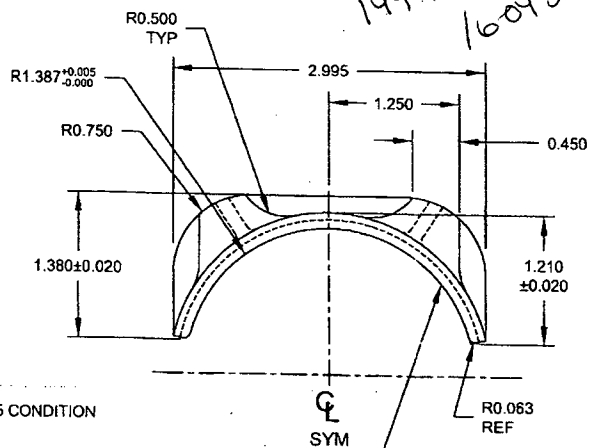
8 7 6 5 4 3 2 1



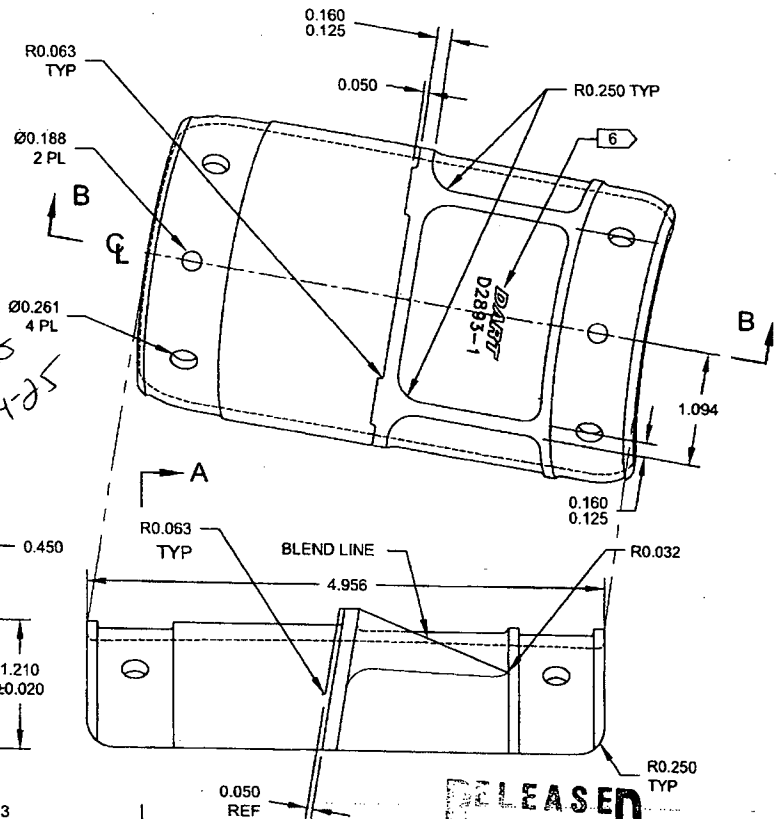
TO CENTER



SECTION A-A
TOOLING HOLE DETAIL



D2893-1 SUPPORT



RELEASED
2011-07-28

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.78 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK
(OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A
ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. D2893	REV. C SHEET 1 OF 1
MFG. APPR.		TITLE Ø2.750 SUPPORT	SCALE NTS
APPROVED			
DE APPR.			
DATE 11.07.15			
COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			